



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3806-043**  
**Job Sheet 199339**



**Part No:** D3806-043

**Job Qty:** 4 pcs

**Part Name:** Wearbar Weldment



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 8/20/19

**Job Tracking No:**

**Due Date:** 9/6/19

**Created By:** Marie Lajeunesse

**Type:** SOLD *ML*

**Description:**

**Note:** DWG REV C SHEETS 2,6 IPP REV:A 16.04.01 NEW ISSUE DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off  |
|-------|---------------------------|----------|------------|----------|-----------|---------|-----------------------------|-----------|-----------|
|       |                           |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |           |
| 110   | Large Fab - Welded Assy-1 | 4<br>pcs | 9/6/19     | 9/6/19   | 0.00      | 0.20    | Large Fab - 1               |           | <i>a</i>  |
|       |                           |          |            |          |           |         | Large Fab - 10              |           |           |
|       |                           |          |            |          |           |         | Large Fab - 2               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 3               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 4               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 5               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 6               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 7               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 8               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 9               |           |           |
|       |                           |          |            |          |           |         | Large Fab - 11 (Various)    |           |           |
| 120   | Automated Welding - B4B   | 4<br>pcs | 9/6/19     | 9/6/19   | 0.00      | 2.00    | Automated Welding - 1 - B4B |           | <i>ML</i> |
| 130   | QC 9                      | 4<br>pcs | 9/6/19     | 9/6/19   | 0.00      | 0.00    | QC 9 - 10                   |           |           |
|       |                           |          |            |          |           |         | QC 9 - 18                   |           |           |
|       |                           |          |            |          |           |         | QC 9 - 24                   |           |           |
|       |                           |          |            |          |           |         | QC 9 - 43                   |           |           |
|       |                           |          |            |          |           |         | QC 9 - 50                   |           |           |
| 140   | QC 5                      | 4<br>pcs | 9/6/19     | 9/6/19   | 0.00      | 0.00    | QC 9 - 9                    |           | <i>KL</i> |
|       |                           |          |            |          |           |         | QC 5 - 10                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 12                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 17                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 18                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 19                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 22                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 24                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 3                    |           |           |
|       |                           |          |            |          |           |         | QC 5 - 43                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 49                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 51                   |           |           |
|       |                           |          |            |          |           |         | QC 5 - 58                   |           |           |



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**Container No:** S213169



**Part:** D3806-043

**Job No:** 199339

**Serial No/Batch:** S213169

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** Various STC's

**Date:** 09/12/19

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|     |                             |       |        |           |                        |
|-----|-----------------------------|-------|--------|-----------|------------------------|
|     |                             |       |        | QC 5 - 68 |                        |
|     |                             |       |        | QC 5 - 9  |                        |
|     |                             |       |        | QC 5 - 50 | EL                     |
|     |                             |       |        | QC 5 - 30 |                        |
|     |                             |       |        | QC 5 - 40 |                        |
|     |                             |       |        | QC 5 - 61 |                        |
|     |                             |       |        | QC 5 - 81 |                        |
| 150 | Packaging 3-1 - Stock - B4B | 4 pcs | 9/6/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |
|     |                             |       |        |           | Packaging 3 - 2 - B4B  |
|     |                             |       |        |           | Packaging 3 - 3 - B4B  |
|     |                             |       |        |           | Packaging 3 - 4 - B4B  |
|     |                             |       |        |           | Packaging 3 - 5 - B4B  |
|     |                             |       |        |           | Packaging 3 - 6 - B4B  |
|     |                             |       |        |           | Packaging 3 - 7 - B4B  |
|     |                             |       |        |           | Packaging 3 - 8 - B4B  |
|     |                             |       |        |           | Packaging 3 - 9 - B4B  |
|     |                             |       |        |           | Packaging 3 - 10 - B4B |
|     |                             |       |        |           | Packaging 3 - 11 - B4B |
|     |                             |       |        |           | Packaging 3 - 12 - B4B |
|     |                             |       |        |           | Packaging 3 - 13 - B4B |
|     |                             |       |        |           | Packaging 3 - 14 - B4B |
|     |                             |       |        |           | Packaging 3 - 15 - B4B |
|     |                             |       |        |           | Packaging 3 - 16 - B4B |
|     |                             |       |        |           | Packaging 3 - 17 - B4B |
|     |                             |       |        |           | Packaging 3 - 18 - B4B |
|     |                             |       |        |           | Packaging 3 - 19 - B4B |
|     |                             |       |        |           | Packaging 3 - 20 - B4B |
|     |                             |       |        |           | Packaging 3 - 21 - B4B |
|     |                             |       |        |           | Packaging 3 - 22 - B4B |
|     |                             |       |        |           | Packaging 3 - 23 - B4B |
|     |                             |       |        |           | Packaging 3 - 24 - B4B |
|     |                             |       |        |           | Packaging 3 - 25 - B4B |
|     |                             |       |        |           | Packaging 3 - 26 - B4B |
|     |                             |       |        |           | Packaging 3 - 27 - B4B |
|     |                             |       |        |           | Packaging 3 - 28 - B4B |
|     |                             |       |        |           | Packaging 3 - 29 - B4B |
|     |                             |       |        |           | Packaging 3 - 30 - B4B |
|     |                             |       |        |           | Packaging 3 - 31 - B4B |
|     |                             |       |        |           | Packaging 3 - 32 - B4B |
|     |                             |       |        |           | Packaging 3 - 33 - B4B |
|     |                             |       |        |           | Packaging 3 - 34 - B4B |
|     |                             |       |        |           | Packaging 3 - 35 - B4B |
|     |                             |       |        |           | Packaging 3 - 36 - B4B |
| 160 | QC 21 - SA                  | 4 pcs | 9/6/19 | 0.00 0.00 | QC 21 - SA - 21        |
|     |                             |       |        |           | QC 21 - SA - 70        |
|     |                             |       |        |           | QC 21 - SA - 53        |

Part Op 110 - Cut blanks at 51.0" \*\*\*EXTRA MAT'L WILL BE CUT AT ASSEMBLY\*\*\*  
 Descriptions: 120 - (Automated welding) \*\*\*SEE NOTE 8 FOR SURFACE BUILDUP\*\*\* 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M139018  
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)  
 140 - (QC5- Inspect part completeness to step on W/O)  
 150 - (Identify as per dwg & Stock Location: W/O) \*\*\*WA001\*\*\*  
 160 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item      | Component Name      | Quantity        | Operation                     | Container |
|------------------|---------------------|-----------------|-------------------------------|-----------|
| M304B0.250x0.500 | 304 Bar .250 X .500 | 17 ft (4.25 ea) | 110-Large Fab - Welded Assy-1 | 5190032   |

| Job Allocations                    |                  |          |           |           |
|------------------------------------|------------------|----------|-----------|-----------|
| Operation                          | Component Part   | Required | Inventory | Allocated |
| 110-Large Fab - Welded Assy-1      | M304B0.250x0.500 | 17       | 211       | 0         |
| Part Specifications                |                  |          |           |           |
| Specifications could not be found. |                  |          |           |           |

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Entered: \_\_\_\_\_

Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. \_\_\_\_\_

Route update only ☐

|                                  |  |                                                                                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              |  |
|----------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------|--|
| Job: _____<br>Part No. _____     |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> |  | <b>DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/><br>Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/><br>Large Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  | MRB (QSI042) |  |
| Date : _____                     |  | Sequence #: _____                                                                                                             |  | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  | Disposition  |  |
| Description Work Order Deviation |  | Completed By                                                                                                                  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              |  |
|                                  |  | Lead hand / Supervisor                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              |  |
|                                  |  | QC / QA Coordinator                                                                                                           |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              |  |

  

|                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                   |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|--|--|--|--|--|--|--|--|-----------------|---------------|------------------|------------------|---------|-----------------------|---------------|-------------------|----------|-----------|-----------------|---------|--------|----------------------|------|--------|------------------------------|---------------------------------|--------------------|-------------------|---------------|-------------|-----------------|---------|------------|--------------|----------------|--|
| <b>Root Cause</b><br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                 | <b>FAULT CATEGORY</b><br><table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> |                   |  |  |  |  |  |  |  |  | Pressure/Forced | Contamination | Power Loss/Surge | Positioned Wrong | Bending | Misaligned/off center | Folio/Program | Outside Tolerance | Crushing | BOM/Route | Grain Direction | Drawing | Cracks | Broken/Damage/Defect | Weld | Finish | Crimp/Kink/Ripple/Wave/Twist | Incomplete/Unclear Instructions | Wrong Stock Pulled | Part Lost/Missing | Marks/Chatter | Drill Holes | Out of Sequence | Misread | Mislabeled | Fit/Function | Off-set/Set-up |  |
| Pressure/Forced                                                                                                                                                                                                                                                                                                                                                                     | Contamination                   | Power Loss/Surge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Positioned Wrong  |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Bending                                                                                                                                                                                                                                                                                                                                                                             | Misaligned/off center           | Folio/Program                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Outside Tolerance |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Crushing                                                                                                                                                                                                                                                                                                                                                                            | BOM/Route                       | Grain Direction                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Drawing           |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Cracks                                                                                                                                                                                                                                                                                                                                                                              | Broken/Damage/Defect            | Weld                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Finish            |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Crimp/Kink/Ripple/Wave/Twist                                                                                                                                                                                                                                                                                                                                                        | Incomplete/Unclear Instructions | Wrong Stock Pulled                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Part Lost/Missing |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Marks/Chatter                                                                                                                                                                                                                                                                                                                                                                       | Drill Holes                     | Out of Sequence                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Misread           |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Mislabeled                                                                                                                                                                                                                                                                                                                                                                          | Fit/Function                    | Off-set/Set-up                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|                                                                                                                                                                                                                                                                                                                                                                                     |                                 | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |  |  |  |  |  |  |  |  |                 |               |                  |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |